

Work Order ID 100079

\*100079\*

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Wednesday, April 17, 2013 4:15:19 PM

Item ID: D4124-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Tab

Stop

\*NS2\*

Start Date: 4/17/2013 Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 4/26/2013 Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals: Process Plan: MF

Date: 13-4-17

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4124	A

100 0.00

\*100\*

Waterjet

Memo

0.00

DAS

05

9-89

13-04-20

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

24

(DAS)  
05  
9-89

13-04-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

24

(DAS)  
05  
9-89

13-04-20

Quality Control

(DAS)  
05  
9-89

13-04-25

NCR: Yes / No

DQA: Date: |

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset	Other								
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

**Work Order ID 100079**

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**\*100079\***

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Item ID: D4124-1

Accept

Revision ID:

Item Name: Tab

Start Date: 4/17/2013 Start Qty: 24.00

**\*24\***

Required Date: 4/26/2013 Req'd Qty: 24.00

**\*24\*****\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC	QC8- Inspect parts - second check Memo	0.00 0.00 9-8 16 0.00 9-8 27	DAS 13-4122 DAS 13-4125			24			
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: ST wa 003 Memo	0.00				24X			SP 13-4-28
140 <b>*140*</b> QC	QC21- Final Inspection - Work Order Release Memo	0.00				13/5/6/28			PT-2
		0.00				MF			13-4-29

NCR:  Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: John Date: 13/05/10QA Closed: CL Date: 13/5/9

Work Order: <u>100079</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4124-1</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> <span style="margin-left: 10px;">X</span> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/> <span style="margin-left: 10px;">X</span> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13-2582</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				Parts were made from wrong mat.	DAS 16 9-09	Script Desy 24 x2f	DAS 05 9-09	AS 27 9-09	DAS 16 9-09
Equip/Tooling				2024 was not 6061. were found when closing w/o's.	052042 13/4/24	Replace Qty 24	13.04.25	3405	052072 13/4/24
Operator	<u>13/4/24</u>	<u>100</u>	<u>24</u>	R.L. operator pulled wrong mat.					
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear		General											
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced				
<input type="checkbox"/>	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure				
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld				
<input type="checkbox"/>	Crushed/Crimped.	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Under	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled				
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>					
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>					
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other				
<input type="checkbox"/>	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>							
<input type="checkbox"/>	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>							
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>							
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>							

**Picklist Print**

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Page 1

**Work Order ID:** 100079**Parent Item:** D4124-1**Parent Item Name:** Tab**Start Date:** 4/17/2013**Required Date:** 4/26/2013**Start Qty:** 24.00**Required Qty:** 24.00**Comments:** IPP Rev:A 10.07.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6,063 Sheet		Purchased	No			100	sf	232.8625	0.03125	0.7894737		m 13.04.20	

Location	Loc Qty	Loc Code
MAT021	232.8625	
123135	120.5625	
124003	112.3	

→ 125341

NCR: Yes / No

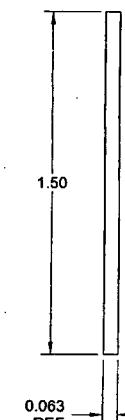
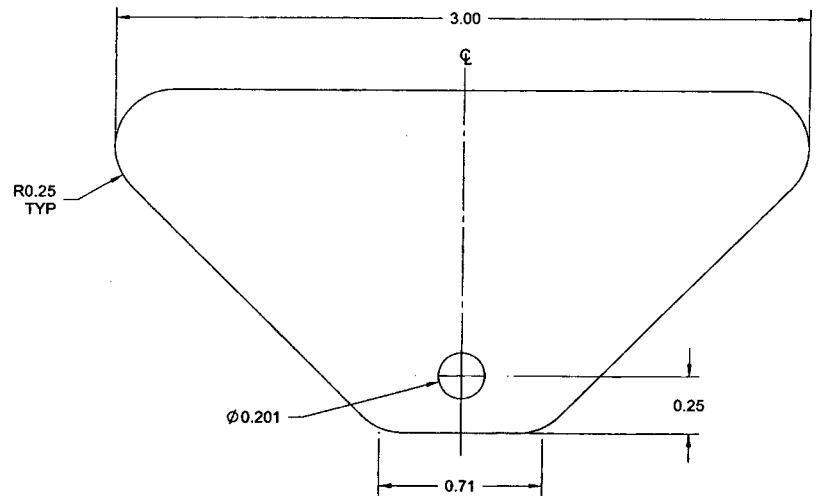
DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS														
Part No. _____			Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>							
NCR No. _____			Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>							
			Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>							
			Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector								
Doc/Data																			
Equip/Tooling																			
Operator																			
Material																			
Setup																			
Other																			
Process																			
Supplier																			
Training																			
Unapproved																			
FAULT CATEGORY																			
Landing Gear				General															
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions								Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge				Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			

100079



D4124-1 TAB

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-CQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	REV. B	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BB</i>		
DRAWN	<i>BB</i>		
CHECKED	<i>BB</i>		
MFG. APPR.	<i>BB</i>		
APPROVED	<i>BB</i>		
DE APPR.	<i>BB</i>		
DATE	10.07.26	SCALE NTS	

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RELEASED  
2011-11-16  
*BB*

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset		Other							
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

DART AEROSPACE LTD	Work Order:	1000079
Description: Tab	Part Number:	D4124-1
Inspection Dwg: D4124	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>W.W.</u>	Audited by: <u>DAS</u> <u>16</u>	Preliminary Approval:
Date: <u>13.04.20</u>	Date: <u>9-59</u> <u>B/67/22</u>	Date:

Rev	Date	Change	Revised By	Approved
A	12.05.15	New Issue	KJ	<i>[Signature]</i>

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order:		DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework	Scrap	Use-as-is	Work Order Update	Skid-tube	Machining	Crosstube	Water Jet	Engineering		
NCR No. _____						Thermoforming	Large Fab	Small Fab	Prod. Eng. Coor.	Quality		
						Composite		Rec/Store/Packaging	Supplier	Other		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear	General											
	Bending	Bend		Grain		Ovalized		Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld				
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved						
	Heat Treat	Countersink		Mislabeled		Positioned Wrong						
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other				
	Ripples in Bend	Drill Holes		Offset								
	Torque Waves in Extrusion	Drawing		Out of Calibration								
	Turning Sequence	Finish		Out of Sequence								
	Wave/Twist in Tube	Folio		Outside Dimensions								

DART AEROSPACE LTD	Work Order:	100079
Description: TAB	Part Number:	D4124-1
Inspection Dwg: D4124 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>all</i>	Audited by:	<i>AS 27 9.00</i>	Preliminary Approval:	
Date:	<i>13.04.25</i>	Date:	<i>13.4.25</i>	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15